Work Order Wednesday, Octob	r ID 74850 ber 12, 2011 9:17:26 AM	·	*748	350*							Page 1
Revision ID:	O3183-045 Bearing Assembly		Accept	*N900	<u>040</u>	100)* s	Setup S	start Stop		S1*
	0/12/2011 Start Qty: 100.0	11717		Cust Item I Customer:	D:				F	"N:	S2*
Approvals:	Process Plan: MF	Date: 1 - 10-12	Tooling:	Da	ate:		R		Start	*NI	२ 1*
	QC:	Date:	SPC (Y/N):	Da	ate:			٤	Stop	*NI	₹2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	*									
D3183	Rev C1	* · · · · · · · · · · · · · · · · · · ·									
*100 *100*	Hardinge CNC LATH	E SMALL	0.00				108	Ø	1		
Hardinge CNC Lathe S	Memo	00.00	0.00								
110 *110* QC	QC2- Inspect parts off Memo	83-9 Cap as per Folio FA388D	_	1010)13			10\$. 4			
Quality Control 120 *120* QC Quality Control	QC8- Inspect parts - se	econd check	0.00 A.A	10/13			105	. 9	<u> </u>		

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Dart Aerospace Ltd

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W/O:			WC	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						<u> </u>				
									L	
Part No		PAR #:								
	Re	solution:					ed:		Date: _ 	
NCR:		•	WORK ORD	ER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC		Corrective Action Section B Action Description Sign &			Verifica		Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng		ate	Sectio	n C	Chief Eng	QC Inspector
							l			
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Work Orde Wednesday, Oct				*748	350*							Page	2
Item ID: Revision ID: Item Name:	D3183-045 Bearing Asserr	nbly		Accept	*N900	04 0	1100)* s	-	tart 1	·NS	S1*	
Start Date: Required Date: Reference:	10/12/2011	Start Qty: 100.00 Req'd Qty: 100.00	*10 *10		Cust Item 1 Customer:	D:					1 111	17	
Approvals:	Process Pla	n:	Date:	Tooling:	D	ate:	_	F	Run S	tart 4	^k NI	₹1*	
	QC:	di.	Date:	SPC (Y/N):		ate:			S	top 🛪	۲N۲	₹2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty			Insp. Stamp	
130		Small Fab							3,11	<u> </u>	Z	10	ر ا
Small Fab Small Fab		Memo Press D3183-	5 Bearing into D3183	0.00 -9 Cap as per Dwg D3183.			1			7 =	/		
				•									
140		QC5- Inspect part complete	teness to step on W/O	0.00				couply	_				
140				8 1.16	0117			(40	(2,				
QC		Mama		0.00	(t \ \ \ \			100	· •———				

150

Identify as per dwg & Stock Location: 236 0.00

150 Packaging

Packaging

Quality Control

Memo

0.00

Dart Aerospace Ltd

W/O:	_			WORK ORDER	CHANGES					
DATE	STEP		PRO	CEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No) :		PAR #:	Fault Category:	NCR:	Yes	No DQ	A:	Date: _	
	F	Resolution:		Disposition:	QA: I	WC C	losed:		Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
	T	Description of NC		Corrective Action Section B		Verification	Approval	Approval			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
								:			
	,										

Work Orde Wednesday, Oct				*748	350*					Page 3
Item ID: Revision ID: Item Name:	D3183-045 Bearing Asser	mbly		Accept	*N900	040	100°	⊁ Setu	p Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	10/12/2011	Start Qty: 100.00 Req'd Qty: 100.00	*100 *100	-	Cust Item I Customer:	D:				IN'2
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #			-	Reject Insp. Number Stamp
*160 *160*		QC21- Final Inspection - \(\text{Memo} \)	Work Order Release	0.00			_	-	11/10	118 4

Memo

Quality Control

Dart Aerospace Ltd

	- Jospace							··
W/O:			WC	ORK ORDER CHANGE	ES			
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date C	Approval Chief Eng / Prod Mgr	Approva QC Inspector
				4424				
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	R	esolution:	Disposition	າ:	QA: NC CI	osed:	Date: _	· · · · · · · · · · · · · · · · · · ·
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCF	R)		
		Description of NC		Corrective Action Section	on B	Verificati	ion Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		QC Inspector
	<u> </u>							

Page 1

Work Order ID:

74850

Parent Item:

D3183-045

Parent Item Name:

Bearing Assembly

Start Date: 10/12/2011

Required Date: 10/19/2011

Start Qty: 100.00

Required Qty: 100.00

Comments:

IPP A04.02.18New issueKJ/DS

Comments.	11 7.04.02.1610	EW ISSUENJ/DS											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3183-5		Manufactured	No			110	Each	42.0000	1	100			
Bearing									<u> </u>	12/	//		
				Location		Loc Qty	Lo	c Code		40	1/10/1	7	
,				ST236		42					, ,		
				6752	29	1					\mathcal{B}	7485	10
				7379	97	1				Tus		737	1 (8 4
				7454	12	40		•		LC)			
MDELRINR1.000	•	Purchased	No			130	f	32.1180	0.0333	\3.505263	2 , ,	()	
Delrin Round Bar 1"									_ >	A	<u> נטן טו</u>	717	
•				Location		Loc Qty	<u>Lo</u>	c Code		•			
				MAT055		32.118							
				_ 1179	985	0.407				$ \wedge$ \wedge			
				1182		18.002				,4 pg			
				1183	192	13.709							

Dart Ae	rospace	Ltd								
W/O:			W	ORK ORDER CH	ANGES					
DATE	STEP	PROC	CEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	_ Fault Cate	egory:	NC	R: Yes	No D Q	A:	Date: _	
	R	esolution:	_ Disposition	on:	QA	: N/C Cld	sed: _		Date: _	
NCR:		W	ORK ORE	ER NON-CONFO	RMANCE	(NCR)			
		Description of NC		Corrective Action	Section B	T	Verif	ication	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descrip		Sign & Date	Sec	tion C	Chief Eng	QC Inspector
										- marting
						1			·	

DART AEROSPACE LTD	Work Order:	
Description: Cap	Part Number:	D3183-9
Inspection Dwg: D3183 Rev: C1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.830	+/-0.005	530			869	
Ø0.720	+/-0.002	.770	///	_	1	
Ø0.747	+/-0.001	.747				
R0.010	+/-0.010	ROID				
R0.031	+/-0.010	3030				
0.199	+/-0.001	158				
0.276	+/-0.010	-277				
0.039	+/-0.010	-040				

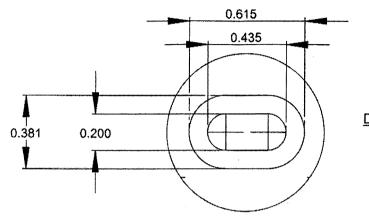
Measured by:		Audited by:	BA	Prototype Approval:	N/A
Date:	· JEM3	Date:	11/10/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.04.20	New Issue (P/O D3183-045)	KJ/RF	1
В	06.03.09	Dimension Ø0.830 was Ø0.850	KJ/JLM 🔏	GH
<u> </u>			, ()	<i>]</i> ,,





DESIGN	DRAWN BY	DART AEROSPAC HAWKESBURY, ONTARIO,	
CHECKED	APPROVED	D3183	REV. C SHEET 4 OF 4
DATE 04	.02.17	BRACKET ASSEMBLY	SCALE 1:1

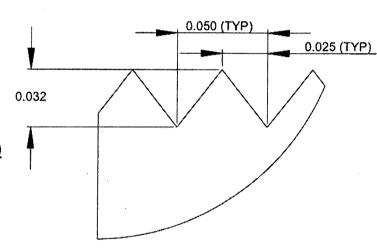


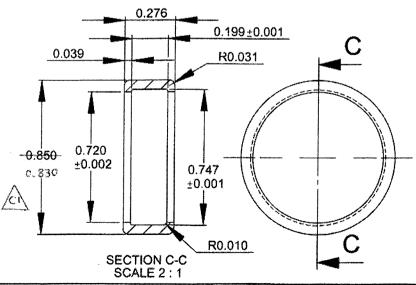
DETAIL A (2:1)

RELEASED

DEO ATTACHED

DETAIL B (20:1)





D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00 (REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

1) ASSEMBLE D3183-5 BEARING AND D3183-9 CAP

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W/O:			WORK ORDER CHANGES							
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
						<u> </u>				
Part No	o:	PAR #:	Fault Category:	NCR: Yes	No DG	A:	Date: _			

	Resolution:		Dispositi	on:	QA: N/C Clos	sed:	Date:	
NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section I		Verification	Approval	Approval QC Inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	
							į	
				1				

DRAWING I		ET ASSEMBLY	REV.C1	DART AEROSPACE L ENGINEERING ORDE		SHEET NO.	SCALE NTS
DRAWN	P	CHECKED	基	MFG. APPR.	APPROVED AN	DE APPR.	WIS
DATE	10.05.14	DATE	10.06.30	DATE (8.06.30	DATE 10/05/30	DATE 10/06/30	

D3183-5 BEARING

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

BASIC LOAD RATING REQUIREMENT:

Cr = 1720 N (386 lb) MIN [DYNAMIC]

Cor = 840 N (188 lb) MIN [STATIC]

REF PAR 10-012



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W/O:			W	ORK ORDER CHANG	ES						
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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			,								
Part No	•	PAR #:	Fault Cate	egory:	_ NCR:	NCR: Yes No DQA: Dat			Date:	ate:	
	R	esolution:	Disposition	on:	QA: N	VC Clos	sed:		Date: _		
NCR:		· V	VORK ORD	ER NON-CONFORM	ANCE	(NCR)		We .			
DATE	0750	Description of NC			tion B		Verific	ation	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		tion C	Chief Eng		
							:				

[€] H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE